

Date: Wednesday, 3/8/2006 10:38:39 AM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BLOWER MOTOR SUPPORT
Job Number	: 26126		
Estimate Number	: 12307		
P.O. Number	: N/A	Part Number	: D34713
This Issue	: 3/8/2006 S.O. No. : N/A	Drawing Number	: D3471 REV.A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : SMALL /MED FAB	Drawing Revision	: A
Previous Run	: N/A	Material	: N/A
Written By	: <u>SAR</u> <u>06/03/08</u>	Due Date	: 3/31/2006
Checked & Approved By	: <u>06/03/08</u>	Qty:	20
Comment	: est rev A 06.03.02 New issue EC	Um:	Each

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	OUTSIDE SERVICE	OUTSIDE SERVICES
-----	-----------------	------------------



Comment: Sub-Contracting OUTSIDE SERVICES

Issue P/O: 00000768

Email or Ship DXF file to vendor

Cut per Dwg D3471 flat pattern D3471-3F

possible supplier: GFI

Material release note required

2.0	D34713F	SUPPORT FLAT PATTERN
-----	---------	----------------------



Comment: Qty.: 1.0000 sf(s)/Unit Total : 12.0000 sf(s)

SUPPORT FLAT PATTERN

3.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Receive &amp; Inspect For Transit Damage

Ensure material certification is attached

4.0	QC6	DIMENSIONAL CHECK
-----	-----	-------------------



Comment: DIMENSIONAL CHECK

Ensure Material certification comply to Dwg D3471

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL &amp; MEDIUM FAB RESOURCE 1




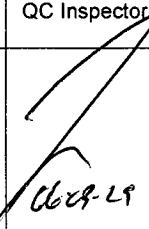
1-Deburr

2-Bend as per dwg D3471

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: ☒ Date: 06/03/20  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/03/20	5	1 piece broke at the bend		Scrap	SP 06/03/20			

NOTE: Date & initial all entries

Date: Wednesday, 3/8/2006 10:38:40 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BLOWER MOTOR SUPPORT

Job Number: 26126

Part Number: D34713

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

JAN 06.03.29

19

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

JAN 06.03.29 19

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 439

C 206103129

19

9.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06103130 19

Job Completion



C 06.03.29

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

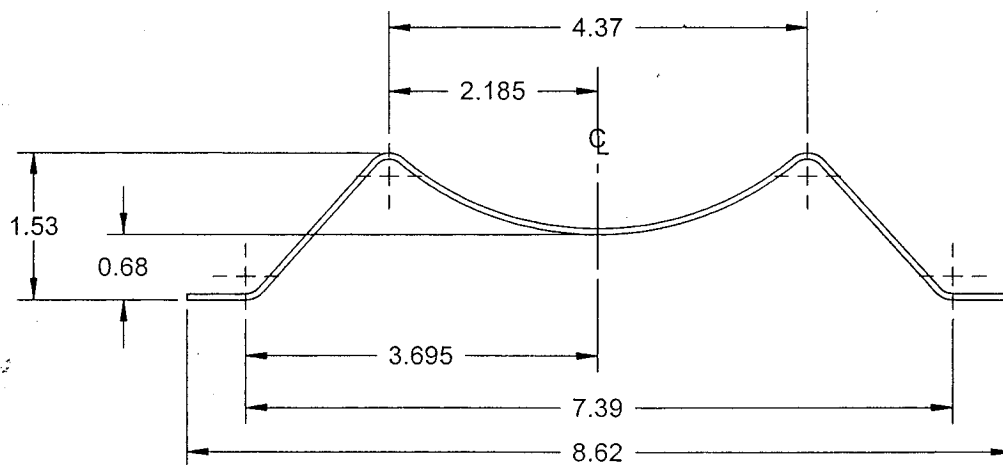
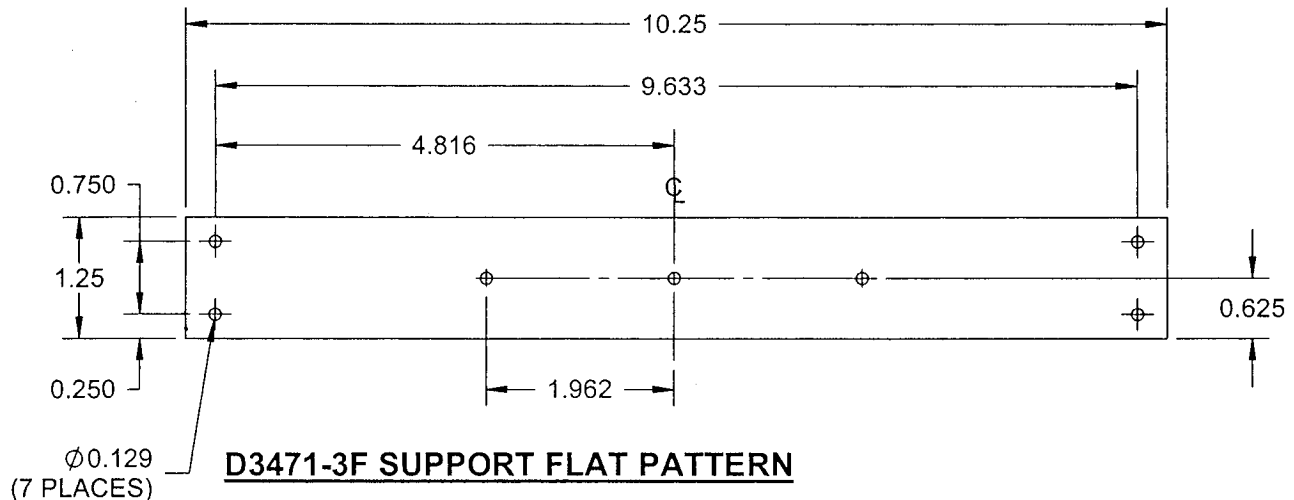
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

PRELIMINARY ISSUE

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3471	REV. A SHEET 4 OF 5
DATE 05.12.21		TITLE BLOWER MOTOR SUPPORT	SCALE 1:2



**NOTES:**

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET (0.063 THICK)  
PER AMS-QQ-A-250/4 OR AMS 4037  
(REF. DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 2) PART IS SYMETRICAL ABOUT CENTER LINE
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

COPYRIGHT © 2005 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

FAX 1 847 585 2500

CORUS ALUMINIUM

Corus Aluminium Walzprodukte G. .1  
 Postfach 100331 · D-56033 Koblenz



# INSPECTION CERTIFICATE (EN 10204/3.1) / TEST REPORT / APPROVED CERTIFICATE

NO.: 0879231 SERIAL-NO.: PAGE: 2 / 03  
 PURCHASER: CORUS ALUMINIUM ROLLED ORDER NO. PURCH.: US-AIRCR. DEPOT-PRO  
 PRODUCTS USA-A DIVIS ORDER NO. MAN.: 83415  
 SCHAUMBURG, IL 60173 SPEC.: AMS4041+B209+QQ290/5  
 CUSTOMER PART NO.:  
 ITEM: 01 LOT: 102973 ALLOY/TEMPER: 2024 T3 ALCLAD 1230 PRODUCT: PLA  
 QUANTITY: 344 DIMENSIONS: 0.040 x 48.00 x 144.00 INS

## Other tests:

Dimensional check: OK  
 Surface control: OK

## Normative references:

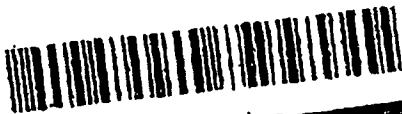
BESTELLNORM/SPECIFICATION/NORME  
 AMS 4041P+ASTM B 209-04+AMS-QQ-A-250/5A SEP1998

## Bend test:

L-direction

LT-direction OK

ST-direction



corus

CERTIFICATE (EN 10204/3-1) / TEST REPORT / APPROVED CERTIFICATE

SERIAL-NO.:  
CORUS ALUMINIUM ROLLED  
PRODUCTS USA-A DIVIS  
CHAUMBURG, IL 60173

PAGE: 3 / 03  
ORDER NO. PURCH.: US-AIRCR. DEPOT-PRO  
ORDER NO. MAN.: 83415  
SPEC.: AMS4041+B209+Q0250/5  
CUSTOMER PART NO.:

THAT THE WHOLE OF THE SUPPLIES DETAILED HEREON HAVE BEEN  
TESTED AND, UNLESS OTHERWISE STATED ABOVE, CONFORM IN ALL  
WITH THE REQUIREMENTS OF THE SPECIFICATION, CONTRACT OR ORDER.

res:

on 28.08.05 SW

G. Mettler  
Quality Assurance

Corus Aluminium  
Walzprodukte GmbH  
Koblenz

MAR-23-2006 04:24 FROM:

TO: 6049464153

Corus Aluminium Walzprodukte G.m.b.H.  
Postfach 400331 · D-56033 Koblenz



INSPECTION CERTIFICATE (EN 10204/3.1) / TEST REPORT / APPROVED CERTIFICATE

NO.: 0879231 SERIAL-NO.: PAGE: 1 / 03  
PURCHASER: CORUS ALUMINIUM ROLLED ORDER NO. PURCH.: US-AIRCR.DEPOT-PRO  
PRODUCTS USA-A DIVIS ORDER NO. MAN.: 89415  
SCHAUMBURG, IL 60173 SPEC.: AMS4041+B209+QQ250/5  
CUSTOMER PART NO.:  
ITEM: 01 LOT: 102973 ALLOY/TEMPER: 2024 T3 ALCLAD 1230 PRODUCT: PLA  
QUANTITY: 344 DIMENSIONS: 0.040 X 48.00 X 144.00 INS

RESULTS:

Mechanical properties:

	Spec. No.	Y.S.	U.T.S.	El.
		KSI	KSI	%
Min. LT:		39,0	59,0	15,0
Max. LT:				
	001	40,6	59,6	17,9
	002	40,6	59,8	18,7
	003	40,8	59,8	17,7
	004	40,8	59,6	18,1

Chemical composition: in % , remainder Al

	ALLOY CORE	ALLOY LINER	ALLOY LINER
	2024	1230 4	1230 4
ALLOY:			
CAST-NO.	5-05-2914	142166-1	142166-1
Si	0,028	0,12	0,12
Fe	0,123	0,26	0,26
Cu	4,326	0,002	0,002
Mn	0,634	0,010	0,010
Mg	1,436	0,003	0,003
Cr	0,001	0,001	0,001
Zn	0,011	0,005	0,005
Ti	0,0278	0,019	0,019
B	0,0006	0,002	0,002
Zr	0,0006		
Pb	0,0016	0,0011	0,0011
Ni	0,0059		